



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB877406-5-1
Job Sheet 176995



Part No: RB877406-5-1

Job Qty: 8 ea

Part Name: Shaft



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/4/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/28/18

Type: SOLD

Description:

Note: DWG RB877406-5 Rev. 1A IPP Rev. A 18.05.01 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	5/28/18	5/28/18	0.00	0.00	Start Up Machining-4		
100	Lathe Conv	8 pcs	5/28/18	5/28/18	0.50	1.00	Lathe Conv-2		
110	QC	8 pcs	5/28/18	5/28/18	0.00	0.00	QC2 Machining-5		
120	QC	8 pcs	5/28/18	5/28/18	0.00	0.00	QC8 Machining-5		
130	Outsource	8 pcs	5/28/18	5/28/18			GRO002-VC		
140	Packaging	8 pcs	5/28/18	5/28/18	0.00	0.00	Packaging2		
150	QC	8 pcs	5/28/18	5/28/18	0.00	0.00	QC6		
160	Packaging	8 pcs	5/28/18	5/28/18	0.00	0.00	Packaging3-2		
170	QC21-SA	8 Ea	5/28/18	5/28/18	0.00	0.00	QC21		

Part Op 100 - Machine as per DWG

Descriptions: 130 - Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required

140 - Receive

160 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.750	1144 Steel Proof Round Bar 0.750"	2.6960 ft (.337 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-R0.750	3	16	2

Allocated Container Detail

Qty	Container No	Location	Init
2	S079021	start up machining-4	

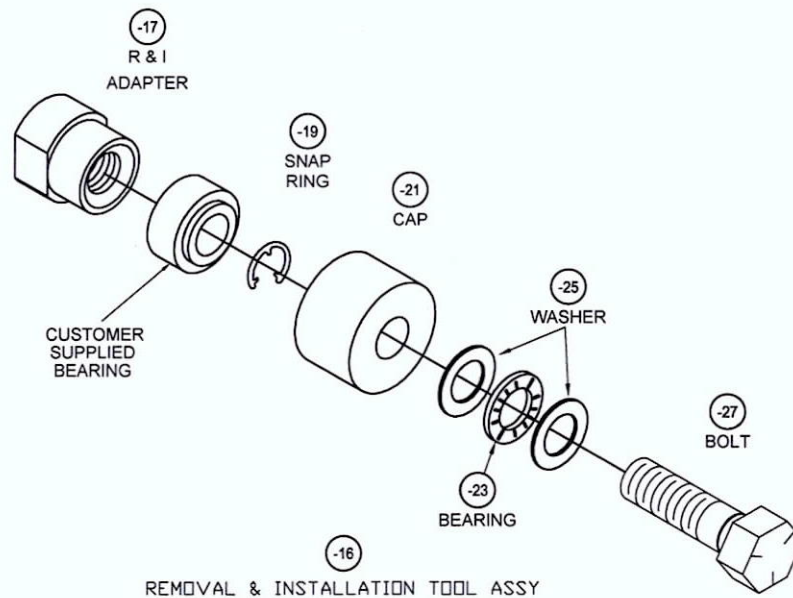
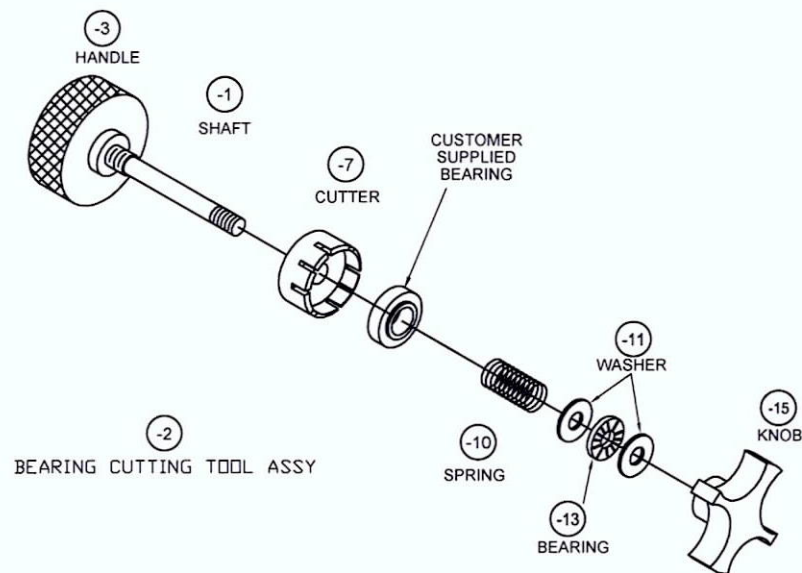
Part Specifications

Specifications could not be found.

Plex 7/4/18 10:47 AM dart.logan.david

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04		
1A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS TO NUMERICAL, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/30/09	RJC	RW



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	Ø3/4 x 4	2
	1		-2	1	BEARING CUTTER TOOL ASSY			1
	1		-3		HANDLE	6061 T6	Ø2 x 3/4	2
	1		-7		CUTTER	01	Ø1-1/16 x 3/4	3
	1	B/O	-10		SPRING	-	5/16 x 2 (EUGENE FASTNER #16)	1
	2	B/O	-11		WASHER	-	TRA-512 (APPLIED INDUSTRIAL)	1
	1	B/O	-13		BEARING	-	NTA512 (APPLIED INDUSTRIAL)	1
	1	B/O	-15		KNOB	-	DK-55 (REID TOOL)	1
	1		-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
	1		-17		R&I ADAPTER	STRESS PROOF	Ø1-1/4 x 1-1/4	4
	1	B/O	-19		SNAP RING	-	Ø5/16 EXTERNAL	1
	1		-21		CAP	6061 T6	Ø1-1/2 x 1	4
	1	B/O	-23		BEARING	-	NTA512 (APPLIED INDUSTRIAL)	1
	2	B/O	-25		WASHER	-	TRA-512 (APPLIED INDUSTRIAL)	1
	1		-27		BOLT	GRADE 5	5/16-24 UNF x 3 MODIFY	4

ASSY QTY -16
ASSY QTY -2

RED BARN MACHINE

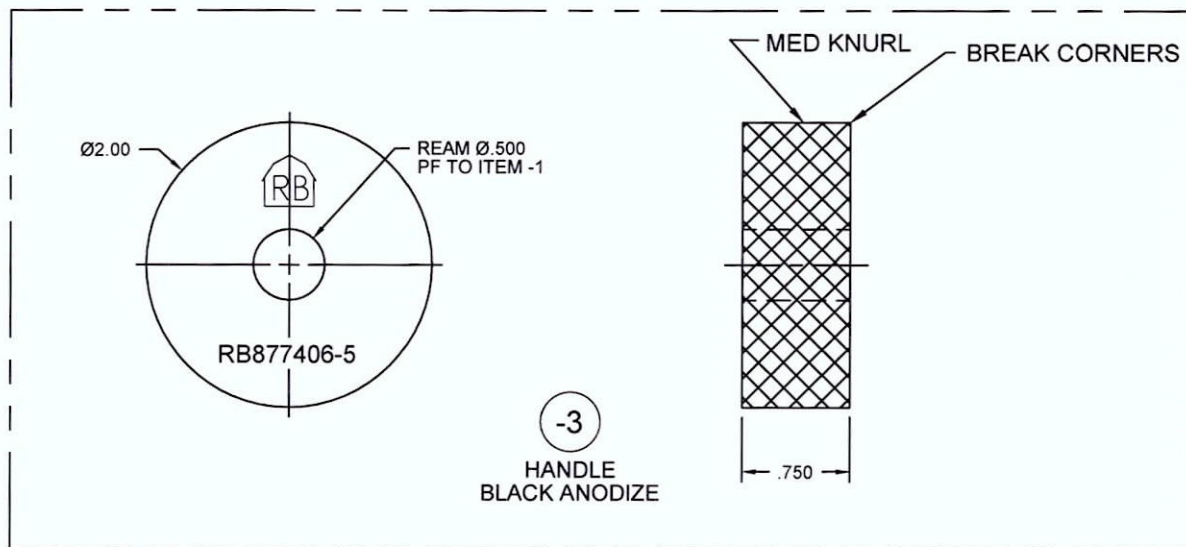
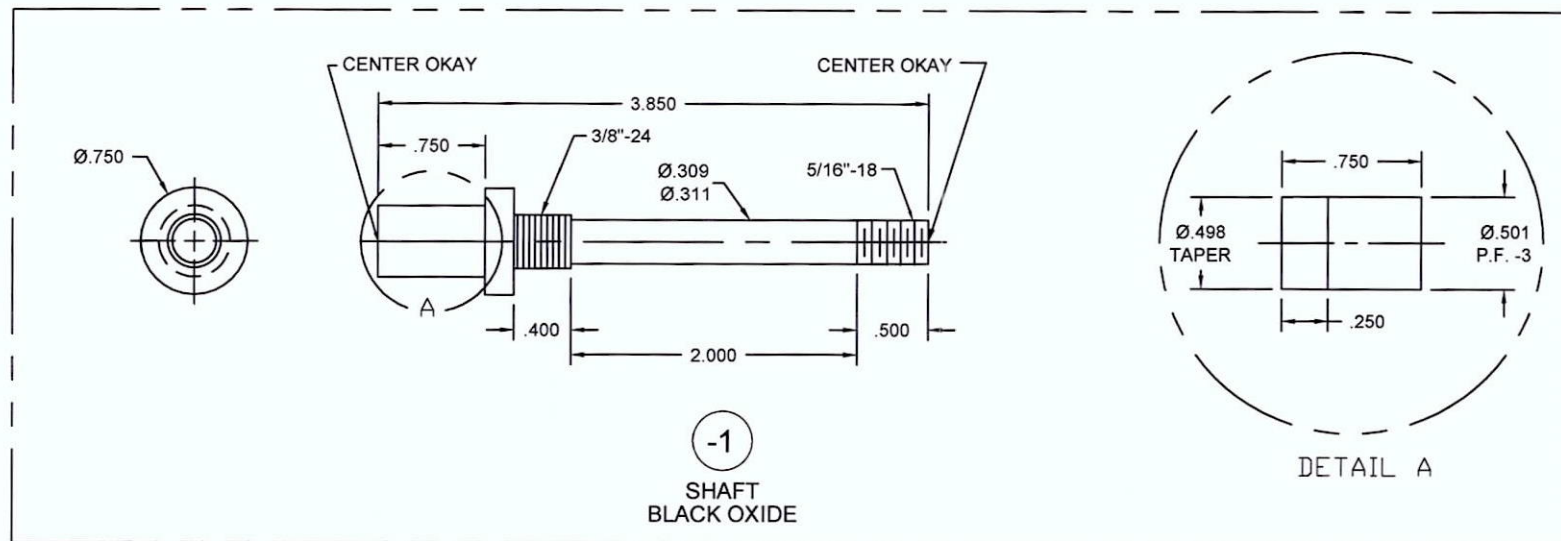
TITLE DAMPER BEARING CUTTING TOOL

DWG NO. RB877406-5 REV 1A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON:		APPROVED	
XXX ± .005	FRACTIONS ± 1/32	HEAT TREAT	
XX ± .01	ANGLES ± 5°	FINISH SPEC	
X ± .1		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		BELL 406	
SCALE NTS	DATE 6-28-01	SHEET 1 of 4	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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			APPROVED
			RW



RED BARN MACHINE	
TITLE DAMPER BEARING CUTTING TOOL	
DWG NO. RB877406-5-1 & -3	REV 1A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS $\pm 1/32$
XXX $\pm .005$	ANGLES $\pm 5^\circ$
XX $\pm .01$	
X $\pm .1$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
DRAWN BY: COLE	
APPROVED	
HEAT TREAT	
FINISH SPEC SEE PART	
USED ON MODEL BELL 406	
SHEET 2 of 4	